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RBE703A95-0520-01-18**Job Sheet 194705****Part No:** RBE703A95-0520-01-18**Job Qty:** 20 pcs**Part Name:** Quill Assembly**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 5/7/19**Job Tracking No:****Due Date:** 6/14/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG RBE703A95-0520-01 Rev K IPP Rev A 18.01.23 New issue DP Verify DD/IPP Rev.B 19.02.27 drawing
revision DP Verify DD/IPP Rev. C 19.05.23 drawing revision DP Verify DD

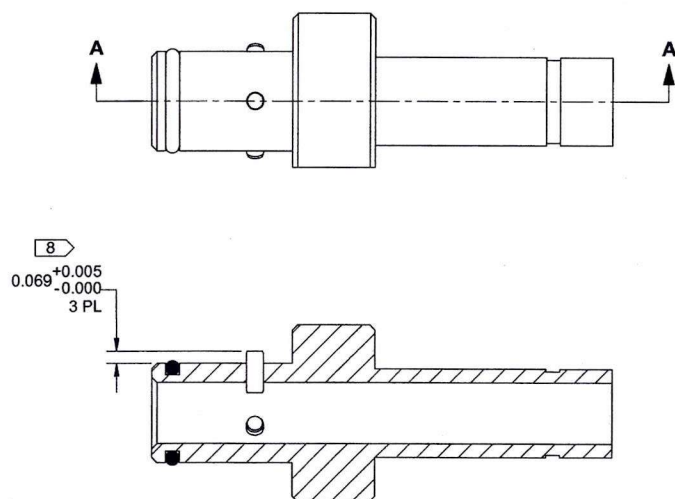
Ship Via:**Bill of Materials**

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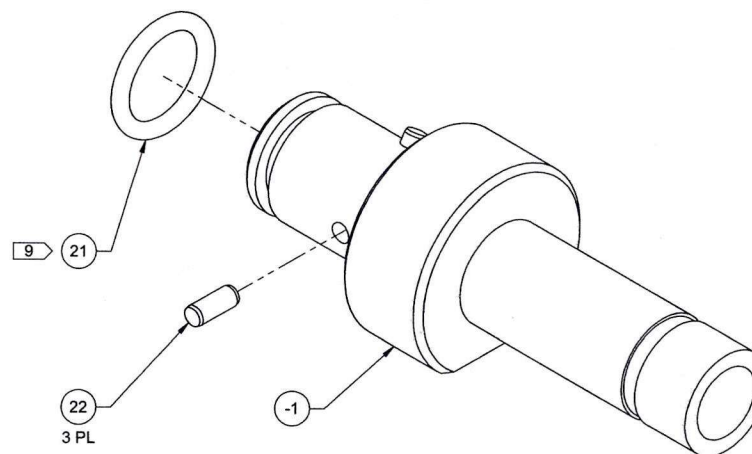
Container No: S191292**Part:** RBE703A95-0520-01-18**Job No:** 194705**Serial No/Batch:** S191292**Revision:** K**Inspector:****Exp Date:****Instructions:****Date:** 06/18/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
100	Small Fab - 1	20 pcs	6/14/19	6/14/19	0.00	4.00	Small Fab - 1		
							Small Fab - 2		MLL
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	20 pcs	6/14/19	6/14/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		DAS 40 9-89
120	Packaging 3-1 - Stock - B4B	20 pcs	6/14/19	6/14/19	0.00	0.00	Packaging 3 - 1 - B4B		JUN 18 2019 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		DAS 28 9-89
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		DAS
130	QC 21 - SA	20 pcs	6/14/19	6/14/19	0.00	0.00	QC 21 - SA - 21		21 9-89 JUN 19 2019
							QC 21 - SA - 70		
							QC 21 - SA - 53		
Part Op Descriptions: 100 - Assemble as per DWG. See note 8 and 9. GA076									
Job BOM									
Part / Item	Component Name	Quantity	Operation	Container					
9263K519	O-ring	20 Ea (1 ea)	100-Small Fab - 1	5161584					
93600A252	316 SS Dowel Pin 2.5 mm Dia. x 6 mm Lg.	60 Ea (3 ea)	100-Small Fab - 1	5175976					
RBE703A95-0520-01-1	Quill	20 pcs (1 ea)	100-Small Fab - 1	5183156					
Job Allocations									
Operation	Component Part	Required	Inventory	Allocated					
100-Small Fab - 1	9263K519	20	60	0					
	93600A252	60	111	0					
	RBE703A95-0520-01-1	20	72	0					

ITEM #	QTY	PART #	PART TITLE
-1	1	RBE703A95-0520-01-1	QUILL
21	1	McMaster#9263K519 OR EQUIV.	VITON O-RING 11 mm ID. X 15 mm OD. X 2 mm THK.
22	3	McMaster#93600A252 OR EQUIV.	316 SS DOWEL PIN 2.5 mm DIA. X 6 mm LG.



SECTION A-A



RBE703A95-0520-01-18 QUILL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 22 WITH ITEM -1, AND REMOVE EXCESS
- 9) APPLY MOLYKOTE 55 OR EQUIVALENT ON ITEM 21 THEN ASSEMBLE WITH ITEM -1 AND REMOVE EXCESS

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. K
MFG. APPR.	DP	RBE703A95-0520-01	SHEET 3 OF 7
APPROVED	W	TITLE	SCALE
DATE	4/24/2019	ENGINE & HYDRAULIC DRAIN TUBE	NTS
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